

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027029**Date Inspected:** 21-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** Watson Bowman Acme**Location:** 95 Pineview, Amherst NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Expansion Joint Hinge A**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2.

This QAI while at WBA observed Joe Kearns performing Flux Core Arc Welding (FCAW) on component SEI112667-CA2-17; using Hobart (Tri-Mark) TM-811N1 electrode under WPS's FCAW-11 (Multi-pass Fillet weld). The welder was observed using a rose bud torch to pre-heat the areas to 115 degrees Celsius. The weld joints being welded by Joe Kearns at the end plate were the external end plate joining the bottom and back plate using an 8mm fillet weld filling a beveled edge of end plate. During the observation Mr. Davis was also noted as checking the welding parameters for compliance to the Welding Procedure Specification (WPS).

Also observed by this QAI was Jason Gray, WBA Welder, welding the bottom plate to the back plate of channel assembly SEI1122667CA2-18. Welding was being performed using the Flux Core Arc Welding procedure FCAW-11. The Parameters of the approved WPS were witnessed being monitored by KTA TATOR CWI Reno Davis. An 8mm fillet weld was being applied to the bevel on the top plate.

Also observed while at WBA was welder John Ash stud welding 7/8" x 8- 1/16" AW108 anchor studs to Support plates SEI112667SP3. Bend tests were performed by Reno Davis, KTA Tator CWI. Full flash was noted by this (QAI) at the base of the studs to the support plate.

This QAI also noted that the top welds of the stiffener plates were not being welded to the face of the plates with the required 10mm fillet weld each side of the stiffener to top plate. This QAI discussed the weld with Reno Davis and was told the decision was made to leave the weld back approx 10 mm from the face as was done on the repaired Channel Assemblies that had the seal weld removed after inadvertently welded. This QAI then called Bajhat Dagher, SMR for clarification. Per Mr. Dagher the welding should be brought out to the face of the weld and the welders should be using run off tabs for the welding. This information was relayed to Mr. Davis and to

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Greg Ross, QC Manager WBA. Mr. Ross assured this QAI the welding would be corrected.

Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and WBA Personell.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Sullivan, Kevin	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
